

Date: Tuesday, 10/24/2006 11:03:29 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LITTER TIE DOWN ASS'Y (LOCKING)
Job Number	: 29136		
Estimate Number	: 10495		
P.O. Number	: N/A	Part Number	: D2360
This Issue	: 10/24/2006 S.O. No. : N/A	Drawing Number	: D2360 / D2341
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C1 / E
Previous Run	: 26489	Material	: N/A
Written By	: <u>JF 06 10 24</u>	Due Date	: 11/5/2006
Checked & Approved By	: <u>JF 06 10 24</u>	Qty:	4 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6201	T Extrusion 4X4X3/8
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Comment: Qty.: 1.1067 f(s)/Unit Total: 4.4268 f(s)
 Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion)
 Batch: B26538

J.F. 06/10/27 (4)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 12.65" Long

J.F. 06/10/27 (4)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio D2341 and Dwg D2341

J.F. 06/10/27 (4)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/10/27 (4)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

9ml 06/10/28 4

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Deburr and Tumble

9ml / J.F. 06/10/27 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 11:03:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 29136

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/10/28 x4

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9/ 06/10/30 x4

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9/ 06/10/31 x4

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10/06/11/20 (4)

11.0

D2002015

Knob



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Knob

B26177

12.0

D2345

Lock Channel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Lock Channel

→

B26457 2X - B29144 (x2)

13.0

D2366

Lock Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Inventory

M19288

14.0

D2367

Handle Knob



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Inventory

→

B26592 2X - B29146 (x2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 11:03:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 29136

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Quick Release

B26497 YX - / B29147 (x4)

16.0

D2373

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spring

B26458 (x4)

17.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pip Pin Assembly

B29379

18.0

AN526C1032R18

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

M101458

19.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

M100793

20.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Washer

M101291

21.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Rivet, Universal Head

M7690

22.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

M101917

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/11/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 11:03:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 29136

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

M13719-

24.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Screw

M18057-

25.0

NAS679A3W

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

M1463-

PU 6/12/31

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2360

M106/11/20

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/06/21

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SI/71

LB 06/11/22

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11/06/23

Job Completion



Wobal.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29136
Description: Litter Tie Down Bracket (Locking)		Part Number:	D2341
Inspection Dwg: D2341	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.500	+/-0.010	1.505"	✓			
1.000	+/-0.010	1.003"	✓			
Ø0.242	+0.005/-0.001	Ø.243"	✓			
Ø0.191	+0.005/-0.001	Ø.192"	✓			
R0.250	+/-0.010	R0.250"	✓			
1.700	+/-0.010	1.699"	✓			
0.750	+/-0.010	.756"	✓			
2.750	+/-0.010	2.756"	✓			
11.000	+/-0.005	10.997"	✓			
5.500	+/-0.010	5.503"	✓			
1.584	+/-0.010	1.592"	✓			
Ø0.191	+0.005/-0.001	Ø.192"	✓			
2.610	+/-0.010	2.619"	✓			
0.844	+/-0.010	.846"	✓			
1.250	+/-0.010	1.256"	✓			
0.750	+/-0.010	.753"	✓			
12.500	+/-0.010	12.500"	✓			
3.313	+/-0.010	3.318"	✓			
4.250	+/-0.010	4.253"	✓			
0.400	+/-0.010	.402"	✓			

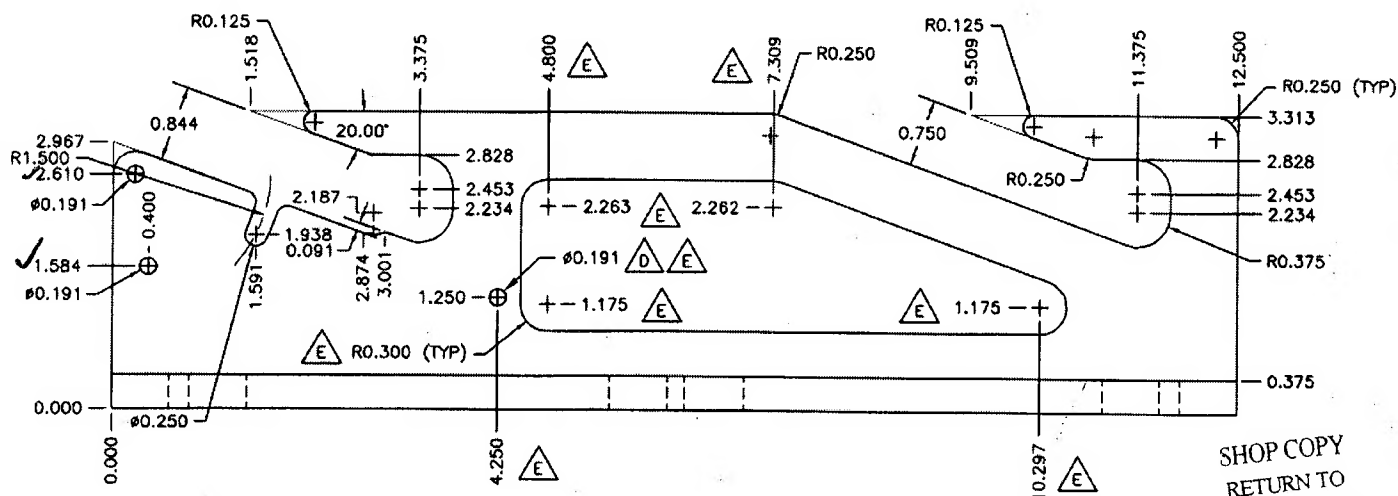
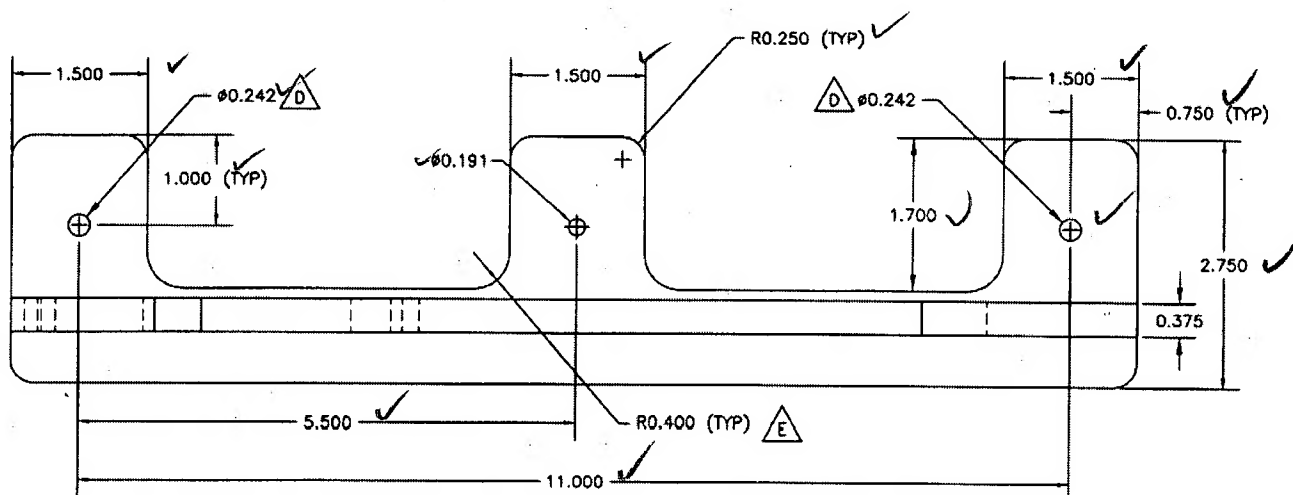
Measured by: J.F.	Audited by: J.G.	Prototype Approval:	N/A
Date: 06/10/27	Date: 06/10/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue	KJ/JLM	



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MM	APPROVED BW	DRAWING NO. D2341	REV. E SHEET 1 OF 1
DATE 97.10.01		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	

RELEASED
971003 KE
TSR A130



MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION
FINISH: ANODIZE

SHOP COPY
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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29136



DESIGN B.W	DRAWN BY B.W	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED KE	APPROVED D101	DRAWING NO. D2360	REV. C SHEET 1 OF 2
DATE 97.08.27		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) SCALE	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
C1	02.09.24	D2002-015 WAS D2376	

RELEASED
97 08 27 BW

D2360	Part No.	Description
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELTRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2376	KNOB (DELTRIN) D2002-015
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
3	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

KE 97.03.02

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WORK ORDER
NO. 29136



DESIGN <i>BW</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>LE</i>	APPROVED <i>MB</i>	DRAWING NO. D2360	REV. C SHEET 2 OF 2
DATE 97.08.27	TITLE LITTER TIE DOWN ASSEMBLY (LOCKING)		

RELEASED
970827 BW

